

Work Order ID 71865 -1

Wednesday, July 13, 2011 11:02:01 AM

Page 1

Item ID: D2648-3

Accept

Setup Start

Revision ID:

Item Name: Wearpad

Stop

Start Date: 7/14/2011 Start Qty: 10.00

Required Date: 7/28/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: mf Date: 11-07-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2648

Rev D

100

0.00



Waterjet

FLOW CNC Waterjet

1010 1063

FLOW WATER JET

Memo

1-Cut as per Dwg D2648

*****CUT WITH FILE D2648-1*****

Dwg Rev: 2

Prog Rev: 2

2-Deburr if necessary

0.00

11/07/26

28

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

11/07/26

28

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

129



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

11/7/27

28

130



Small Fab

Small Fab

Small Fab

0.00

Memo

Deburr if necessary

0.00

N/A

140



Brake NC

Brake NC

NC BRAKE

0.00

Memo

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.
2-Identify as D2648-3

0.00

SB 11/6/27

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Large Fab

Large Fab

Weld per dwg A/R Hardcoat steel Batch: M117964 0.00
Large Fab

Memo

0.00

1-Weld as per Dwg D2648 using Jig DT 8210
2-Remove any weld that penetrated through Wearpad if necessary

11-7-27 (12)

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo

0.00

11.07.27 (12)

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

11.07.27 (12)

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M 117338

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:20
350°
10:50*

12. 0 BL. 11-7-27.

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

change place 50

12 d 11 11/10/07

200



Packaging

Packaging

Identify as per dwg & Stock Location

237

0.00

Memo

0.00

11/12/07

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/h/27

p 1107-27

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Picklist Print

Wednesday, July 13, 2011 11:01:59 AM

Page 1

Work Order ID: 71865



Parent Item: D2648-3



Parent Item Name: Wearpad


Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF
IPP Rev:F Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 		Purchased	No			100	sf	150.5000	0.075	0.789474			

1010/1025 sheet 16GA

Location

MAT019

116791

117500

Loc Qty

150.5

32.5

118

Loc Code

~~2.8~~

3.2

11/07/26

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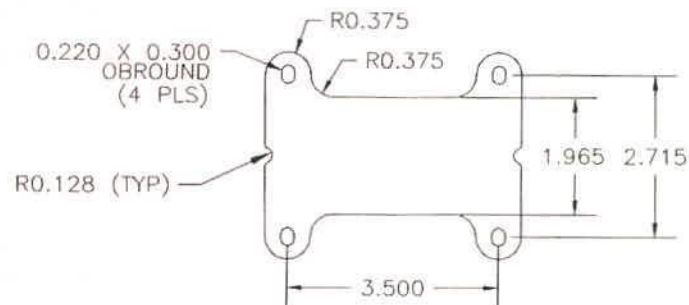
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

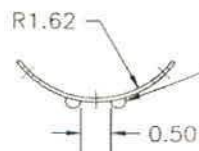
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D2648-1 FLAT PATTERN

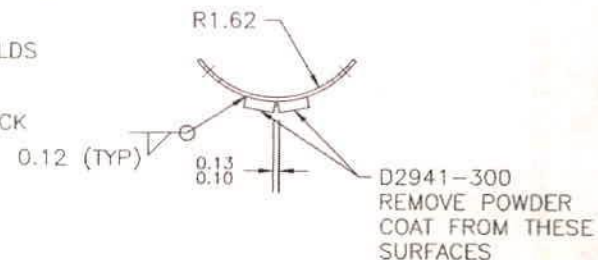


SECTION A-A

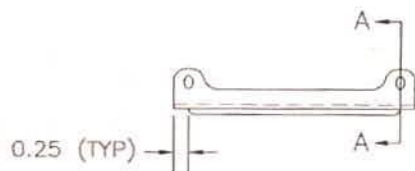


7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B



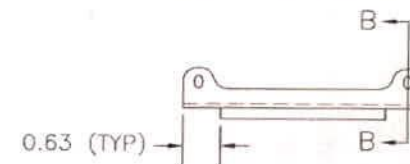
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED
199.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE		TITLE WEARPAD
99.11.17		SCALE 1:2

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